



Dart Aerospace Ltd.
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D5331-041
Job Sheet 169866



Part No: D5331-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 2/2/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2,4,5,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27
add D4016-7 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/1/18	0.00	0.00	Start Up Large Fab-6		2018-01-31
100	Large Fab	1 pcs		2/1/18	0.00	15.77	Large Fab 1		2018-02-07
110	QC	1 pcs		2/1/18	0.00	0.00	QC9		18-02-12
120	QC	1 pcs		2/1/18	0.00	0.00	QC5		18-02-12
125	HandFinish	1 pcs		2/1/18	0.00	2.34	HandFinish2		2018-02-14
130	Powdercoat	1 pcs		2/2/18	0.00	0.53	Powdercoat2		18-2-14
140	QC	1 pcs		2/2/18	0.00	0.00	QC3		18-2-14
170	Packaging	1 pcs		2/2/18	0.00	0.00	Packaging3-2		18-2-14
180	QC21-SA	1 Ea		2/2/18	0.00	0.00	QC21		2018-02-14

Part Op 100 - 1- Assemble ribs and weld as per dwg D5331 using DT10197 ***inspect before welding mesh*** (54.63)
Descriptions: CRITICAL DIMENSION)*** 2- Weld gusset and handle plate as per dwg 3- Cut mesh as per dwg D5328-1 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331 ***Take lid to locate hinge and bracket*** On one of the hinge weld stopper D4016-7 as per dwg*** 6- Weld D5325-5 foot as per dwg (CRITICAL)

130 - 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: 1:45
OVEN TEMPERATURE: 375 FINISH TIME: 5:05
COAT: START TIME: 3:15 OVEN TEMPERATURE: FINISH TIME: 2ND COAT: START TIME: 5:05 FINISH TIME: 5:45

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5033599	2	30	0	0
	D3913-15 5014390	1	9	0	0
	D3916-5 5033990	2	23	0	0
	D4016-1 5031748	6	17	0	0
	D4016-7 158867	1	4	0	0
	D4021-1 5010955	1	29	0	0
	D5325-041 163116	1	1	0	0
	D5325-3 5005650	1	1	0	0
	D5325-5 163107	4	4	0	0
	D5326-041 163091	1	1	0	0
	163092-D5326-043 163103	1	1	0	0
	D5327-1 158897	1	6	0	0
	D5327-11 163104	4	4	0	0
	D5327-13 163093	1	1	0	0
	D5327-15 161209	1	11	0	0
	D5327-3 5005658	1	1	0	0

D5327-5	5005651	1	1	0	0
D5327-7	5005653	1	2	0	0
D5327-9	163112	2	2	0	0
D5328-3	5008229	1	4	0	0
D5328-5	163113	1	2	0	0
D5329-1	162099	2	6	0	0
D5330-1	161957	2	2	0	0
M304EX0.75-16F	5034189	32	1,211	0	0

Part Specifications

Specifications could not be found.

Plex 1/2/18 12:53 PM dart.poulin.mario

DART
AEROSPACE

S037635



Basket Base Assembly, LH

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PART NO: D5331-041

Original Serial #: S037635

Revision:

Operation:

Change No:

Start up Operation 01/31/18

Job No: 169866

Master Unit 000330



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